



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB877528-4
Job Sheet 170014



Part No: RB877528-4

Job Qty: 4 Ea

Part Name: Pitchlink Bearing Cutter



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/8/18

Job Tracking No:

Due Date: 1/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Customer: Paradise Helicopters (CPARA06)

73-341 U'U Street Kailua-Kona, HI, 96740 USA ph:(808) 329-8488

Note: DWG REV 3

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	1/9/18	1/9/18	0.00	0.00	Start Up Small Fab-4		MLC
110	Small Fab	4 pcs	1/9/18	1/9/18	0.00	0.00	Small Fab-9		MLC DAS
120	QC	4 pcs	1/9/18	1/9/18	0.00	0.00	QC4		38
140	QC21-SA	4 Ea	1/9/18	1/9/18	0.00	0.00	QC21		9-88

Part Op Descriptions: 110 - 1-Pick kit 2-Bag and tag

DAS
21
9-88

FEB 27 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	RB877528-4-16	4	0	0	0
	RB877528-4-2	4	0	0	0

Part Specifications

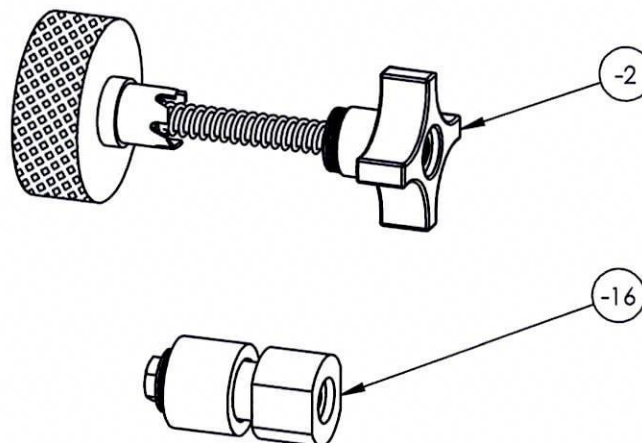
Specifications could not be found.

Plex 1/8/18 9:10 AM Dart.lajeunesse.marie

DART
AEROSPACE
Container No: S045949
Part: R8877528-4
Job No: 170014
Serial No/Batch: S045949
Revision: R8877528-4
Inspector:
Date: 02/27/18
Dart Aerospace Ltd.
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-7 RADIAL ANGLE INCREASED FROM 2° TO 5° TO IMPROVE OPERATION.	2/19/2004	-	-
2		CH'D NOTE P/N -7 TURN TO FROM .660 PER GABRIEL. CH'D REVISIONS TO NUMERICAL, CH'D TITLEBLOCK & REVISION BLOCK, MADE SECTION VIEW A-A P/N -6, LABELED SECTIONS B-B P/N -17, & SECTION C-C P/N -21.	7/27/2009	RJC	-
3	15-0104	UPDATED TO NEW DRAFTING STANDARDS. -1 CH'D DIM WAS Ø.501 IS Ø.5012-.5016. ADDED DIM .10. DELETED TAPER. DELETED DIM 2.000. ADDED DIM 2.50. ADDED MIN. RELIEF. -10 CH'D B/O INFO WAS EUGENE FASTENER #16 IS MCMASTER-CARR #9657K122. -11 ADDED QTY 2 TO -16 ASSY. -13 ADDED QTY 1 TO -16 ASSY. -17 DELETED DIMS .493, .420. ADDED DIM 43.6°. CORRECTED TYPO ON THREAD CALLOUT. -19 ADDED B/O INFO #97633A130. -23 & -25 DELETED. -27 CH'D DIM WAS .030 IS .030 +.005 -.000. ADDED B/O INFO #91247A014. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	5/13/2015	DPD	JAG



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WITHOUT NOTICE
WORK ORDER
NO. 10014 MJS
18-01-08

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	1		-1		SHAFT	STRESSPROOF		2
	X		-2	1	CUTTER ASSEMBLY			3
	1		-3		HANDLE	6061 T6		4
	1		-7		6 TOOTH CUTTER	Q-1		5
	1	B/O	-10		SPRING	STEEL	Ø.437 OD X Ø.054 WIRE X 2, 15.54 LBS./IN. (MCMASTER-CARR #9657K122)	3
2	2	B/O	-11		WASHER	STEEL	TRA-411 (APPLIED INDUSTRIAL)	3 & 6
1	1	B/O	-13		BEARING	Alloy Steel	NTA-411 (APPLIED INDUSTRIAL)	3 & 6
	1	B/O	-15		KNOB		1/4-20 (ESSENTA COMPONENTS #DK-54)	3
	X		-16	1	REMOVE & INSTALL TOOL			6
	1		-17		R & I ADAPTER	STRESSPROOF		7
	1	B/O	-19		SNAP RING	STEEL	Ø1/4 (MCMASTER-CARR #97633A130)	6
	1		-21		CAP	6061 T6		8
	1		-27		BOLT	STEEL	1/4-28 X 1-3/4 (MCMASTER-CARR #91247A014) MODIFIED	9
ASSY -16	ASSY -2							

		TITLE		DAMPER BEARING TOOL KIT	
		DWG NO.		RB877528-4	
		REV		3	
MAT'L		DRAWN BY:		PERRITT	
UNLESS OTHERWISE SPECIFIED		APPROVED		<i>D. Weir</i>	
DIMENSIONS ARE IN INCHES		TREAT			
.XXX ± .005		FINISH			
.XX ± .01		SPEC			
.X ± .1		ANGLES ± 5°			
1. BREAK ALL SHARP EDGES .015 x 45°		USED ON MODEL			
OR .015R		MD 500D			
2. DIMENSIONAL LIMITS APPLY AFTER PLATING					
SCALE 1:2		DATE 6/28/2000		SHEET 1 OF 9	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					